Date:

Tuesday, 30/09/2008 11:14:22 AM

User:

Julie Lecocq

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 42361

Estimate Number P.O. Number

: 10313

This Issue

: 30/09/2008

: NC

: //

: 41897

Type

S.O. No. :

: SMALL /MED FAB

Part Number

Drawing Name

: D26483

Drawing Number

: D2648 REV D

: WEARPAD

Project Number

: N/A

Drawing Revision

; D

Material **Due Date**

KJ/RF

: 15/10/2008

Qtv:

10 Um:

Each

Previous Run Written By

Prsht Rev.

First Issue

Checked & Approved By

Comment

02.09.18 Re-format; Incorporated D2648-1

Now on Waterjet 06-08-14 Est Rev:F

Additional Product

Job Number:



Sea. #:

Machine Or Operation:

Description:

1.0

M1010S16GA

1010/1025 sheet 16GA



Comment: Qty.:

0.0788 sf(s)/Unit Total: 0.7875 sf(s)

1010/1025/A21/6aA SHEET

(M1010S16GA)

Batch: 165706

B 8-10-38

2.0

WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2648

Prog Rev:_____

HB 8-10-28

2-Deburr if necessary

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



138-10-38

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.0

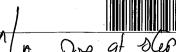
SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary



Page 1

Form: rprocess

Dart Aerospa	ce	Ltd
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	1									
W/O:			W	ORK ORDER CHANG	GES	., ,		-		
DATE	STEP	PROCEDURE CHANGE			E	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:		PAR #:	Fault Ca	tegory:	NCR:	Yes N	o DQ	A:	Date:	
			Disposition: QA							
NCR:		,	WORK OR	DER NON-CONFORM	IANCE (NCR)			A,	
DATE	STEP	Description of NC		Corrective Action Section B			Verification			Approval
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C		Approval Chief Eng	QC Inspector
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NOTE: Date & initial all entries

	Tuesday, 30/09/2008 11:14:22 AM Julie Lecocq	Process Sheet
Custon	ner: CU-DAR001 Dart Helicopters Services	
Custon	ner. Co-DAI (001 Dail Ficilicopters del vices	Staving Name. WEATH AD
Job Numi	ber: 42361	Part Number: D26483
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	BRAKE NC	NC BRAKE
Cor	mment: NC BRAKE	
		NC brake using Jigs DT 8261 and DT 8326
	2-Identify as D2648-3	Sh S (10/20 (18)
7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Cor	mment: LARGE FABRICATION RESOUR	RCE 1
	Qty Description	Batch
	-	109560
	1-Weld as per Dwg D2648 using	Jig DT 8210 ted through Wearpadif necessary ET 8-/1-/0- X/D
8.0	QC10	VISUAL INSPECTION OF GROUND WELDS
		{
	mment: VISUAL INSPECTION OF GROU	O OBMATIN ()
9.0	QC5	INSPECT WORK TO CURRENT STEP
Cor	mment: INSPECT WORK TO CURRENT	STEP STEP
10.0	POWDER COATING	POWDER COATING
		~136 442
Cor	mment: POWDER COATING	~ 196 172
	Powder Coat Grey Sandtex (Ref:	4.3.5.6) as per QSI 005 4.3
		(\mathcal{C})
	START TIME: 3 2	20
		00
		50
11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Cor	mment: INSPECT POWDER COAT/CHE	MICAL CONVERSION
12.0	PACKAGING 1	PACKAGING RESOURCE #1
•		
Con	nment: PACKAGING RESOURCE #1	
	Identify and Stock Location:	16 MI-A- 08/11/12

	oopaoc								
W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:		PAR #:	Fault Cat	tegory:	Date: _				
Resolution:			Disposit	_ QA: N/C CI	A: N/C Closed: Date:				
NCR:		\	WORK ORI	DER NON-CONFORM	ANCE (NCF	R)			
DATE	STEP	Description of NC	Corrective Action Section B			Verification		Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti	ion C	Chief Eng	QC Inspector
							· <u></u>		
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1									

NOTE: Date & initial all entries

Date: User: Tuesday, 30/09/2008 11:14:22 AM

Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 42361

Part Number: D26483

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

QC21

FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

		·								
W/O:		,	W	ORK ORDER CHANG	GES					
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
										-
									· · · · · · · · · · · · · · · · · · ·	
Part No:		PAR #:	Fault Cat	egory:	_ NCR:	Yes N	lo. DQ	A:	_ Date: _	
Resolution:			Dispositi	QA: I	_ QA: N/C Closed:					
NCR:			WORK ORI	DER NON-CONFORM	ANCE	(NCR)				
DATE	STEP	Description of NC	Corrective Action Section B			Verification			Approval	Approval
DAIL	SILI	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C		Chief Eng	QC Inspector
				·		٠				

NOTE: Date & initial all entries

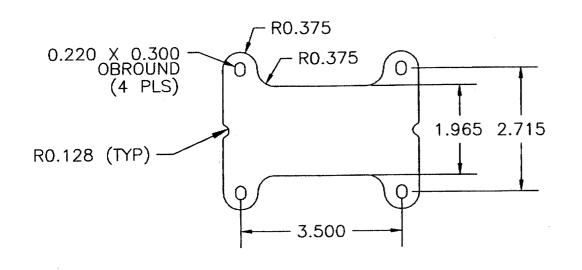
DART AEROSPACE LTD	Work Order:	42361
Description: Wearpad	Part Number:	D2648-3
Inspection Dwg: D2648 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST									
	X First Article Prototype								
	wing nsion	Tolerance	Actual Dimension	Accept	Reject	Method o		mments	
1.9	965	+/-0.010	1.966	8					
2.7	715	+/-0.010	9.711	%					
3.5	500	+/-0.010	3,498	×					
0.220	x 0.300	+/-0.010 x +/-0.010	999 X309	×					
R0.	375	+/-0.010	375	15			·		
R0.	128	+/-0.010	- 198	×					
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Measur	ed by:	B	Audited by:	<u>></u> ,	,	Prototyp	e Approval:	N/A	
	Date:	8-10-28	Date:	08/10	108		Date:	N/A	
Rev	Date	Change			· · · · · · · · · · · · · · · · · · ·		Revised by	Approved	
Α	06.10.1						KJ/JLM	- [41]	

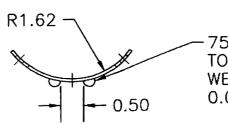
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D2648-1 FLAT PATTERN



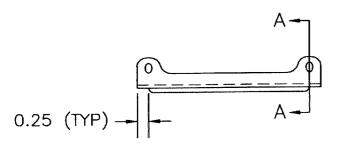
SECTION A-A



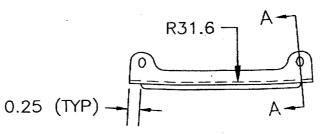
7560 HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.063 TO 0.125 THICK

- D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

D2648-3 LONGITUDINAL BEND (MADE FROM D2648-1)

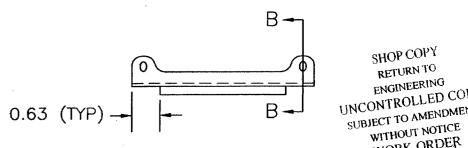


D2648-5 LONGITUDINAL BEND (MADE FROM D2648-1)



D2648-7 LONGITUDINAL BEND (MADE FROM D2648-1)

SECTION B-B



99.11.17

97.06.26

97.05.30

RELEASE GR.(2.20 DS)

ADDED D2648-7
R31.6 WAS R19.6
ENLARGE OBROUND, 0.375 WAS 0.250
NEW ISSUE

A 97.03.25 NEW ISSUE

DESIGN DRAWN BY

RF

DART AEROSPACE USA, INC.
BELLEVIE, WA

REV. D

DATE

TITLE

SCALE

99.11.17

NEW ISSUE

DART AEROSPACE USA, INC.
BELLEVIE, WA

REV. D

SHEET 1 OF 1

WEARPAD

1:2

BREAK ALL SHARP CORNERS 0.063 MAX

MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)

FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES